



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4895-047
Job Sheet 173512-A



split

Part No: D4895-047

Job Qty: 1 ea

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 3/5/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
172	QC	1 pcs	3/5/18	3/5/18	0.00	0.00	QC3		
180	Small Fab	1 pcs	3/5/18	3/5/18	0.00	0.24	Small Fab-8		
190	QC	1 pcs	3/5/18	3/5/18	0.00	0.00	QC5		
200	Packaging	1 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3-2		
210	QC21-SA	1 Ea	3/5/18	3/5/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4859-1	Bushing	4 Ea (4 ea)	180-Small Fab	F147406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
180-Small Fab	D4859-1	4	16	0

Part Specifications

Specifications could not be found.

Plex 5/8/18 10:57 AM dart.lacelle.linda

DART
AEROSPACE

Container No. S0696888

Part: D4895-047

Job No: 173512-A S047892

Serial No/Batch:

Inspector:

Date: 06/08/18

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D4895-047

Job Sheet 173512



Part No: D4895-047

Job Qty: 3 ea

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV B IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	3 Ea	3/2/18		0.00	0.00	Start Up Waterjet		
100	Waterjet	3 pcs	3/2/18		0.00	2.36	Waterjet1		18/03/01
110	CNC Vertical Machining	3 pcs	3/3/18		0.62	8.82	HAAS1-5		18/03/01
120	QC	3 pcs	3/3/18		0.00	0.00	QC2 Machining-3		18-05-05
150	QC	3 pcs	3/3/18		0.00	0.00	QC8 Machining-3		18-05-05
160	HandFinish	3 pcs	3/3/18		0.00	0.57	HandFinish1		18/05/08
170	QC	3 pcs	3/3/18		0.00	0.00	QC7-4		18-05-08
171	Powdercoat	3 pcs	3/3/18		0.00	0.32	Powdercoat1		18-05-08
172	QC	3 pcs	3/3/18		0.00	0.00	QC3		18-05-08
180	Small Fab	3 pcs	3/5/18		0.00	0.71	Small Fab-8		
190	QC	3 pcs	3/5/18		0.00	0.00	QC5		
200	Packaging	3 pcs	3/5/18		0.00	0.00	Packaging3-2		
210	QC21-SA	3 Ea	3/5/18		0.00	0.00	QC21		

M13860

START: 9.35

OUT: 3.30

FINISH: 11.05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	9.0300 ft (3.01 ea)	90-Start up Operation	
D4859-1	Bushing	12 Ea (4 ea)	180-Small Fab	M1385412 80

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	9	16	0
180-Small Fab	D4859-1	12	16	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 1:46 PM dart.logan.david

Add 12.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 13512
Description: Aft Outboard Beam		Part Number: D4895-7
Inspection Dwg: D4895	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓		Tape	ref.
	R1.50	+/-0.030	R1.500	✓		R-G	ref.
	R0.38	+/-0.030	R0.375	✓		"	"
	4.63	+/-0.030	4.625	✓		H-G	31006
	5.75	+/-0.030	5.748	✓		Vern	GA-13
	0.250	+/-0.010	0.249	✓		Mic	GA-03
	0.150	+/-0.010	0.149	✓		Vern	GA-13
	3.00	+/-0.030	2.998	✓		"	"
	R0.43	+/-0.030	R0.430	✓		R-G	ref.
	0.200	+/-0.010	0.201	✓		Mic	GA-03
	0.750	+/-0.010	0.748	✓		Vern	GA-13
	Ø0.425	+0.000/-0.002	0.4245	✓		Mic/T-6	GA-03/ref.
	6.97	+/-0.030	6.973	✓		H-G	31006
	0.93	+/-0.030	0.928	✓		Vern	GA-13
	0.85	+/-0.030	0.848	✓		"	"
	1.00	+/-0.030	1.014	✓		"	"
	R0.13	+/-0.030	R0.125	✓		R-G	ref.
	0.150	+/-0.010	0.152	✓		Mic	118-120
	Ø0.377	+0.006/-0.001	Ø0.378	✓		Vern	GA-13
	3.00	+/-0.030	2.997	✓		"	"
	1.15	+/-0.030	1.150	✓		"	"
	Ø1.00	+/-0.030	Ø0.998	✓		"	"
	2.300	+/-0.005	2.300	✓		"	"
	0.60	+/-0.030	0.600	✓		"	"
	0.80	+/-0.030	0.799	✓		"	"
	3.600	+/-0.005	3.600	✓		"	"
	1.800	+/-0.005	1.800	✓		"	"
	1.75	+/-0.030	1.7485	✓		"	"
	3.50	+/-0.030	3.497	✓		"	"
Manual Mill	0.25	+/-0.030	0.254	✓		D-G	GA-08
	5.50	+/-0.030	5.502	✓		Vern	GA-13
	12.000	+/-0.005	12.000	✓		Vern	CNC-02
	1.55	+/-0.030	1.551	✓		"	"
	Ø0.465 X 90°	+/-0.010 x 0.5°	Ø0.473 x 90°	✓		"	"
	R0.25	+/-0.030	R0.250	✓		R-G	ref.
	0.500	+/-0.010	0.498	✓		Mic	GA-03

Measured by: A.E	Audited by: [Signature]	Preliminary Approval:
Date: 18-05-05	Date: 18/05/08	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	[Signature]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								